

Date: Thursday, 22/01/2009 2:33:17 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET ASSEMBLY
Job Number :	45086		
Estimate Number :	10290		
P.O. Number :		Part Number :	D3121144
This Issue :	22/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3121 REV E
First Issue :	1/1	Project Number :	N/A
Previous Run :	43604	Drawing Revision :	E
Written By :		Material :	
Checked & Approved By :	<u>J.D. 09.01.22</u>	Due Date :	05/02/2009
Comment :	Est Rev: Pick: A 04.02.18 New issue KJ/DS Est Rev: B ECN 1060 07-11-12 DD verified by: EC Est Rev: C New Dimensions for Blank Size 08-07-23 JLM Verified By: EC		

Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M174B1250X02000	17-4 SS Bar 1.250 x 2.00
-----	-----------------	--------------------------



Comment: Qty.: 0.3864 f(s)/Unit Total: 3.8640 f(s)

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1.250 x02.000)

Identify for D3121-114

Batch: 4109850

mk 09/01/23

(10) (11)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: (1.250" x 2.000") 4.425" long

mk 09/01/23

(10) (11)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114

2-Deburr

3-Scribe batch number

J.F. 09/01/26

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/01/26

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-144 PAR #: N/A Fault Category: Prod / Machined Part NCR: Yes No DQA: D Date: 09/02/03
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/02/03

NCR: 45086		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/26	3.0	1 part is scrap, the part moved during machining Dim. .160", 1.590", 2.220, 2.540 are off by .045" Tool pushed against the		Scrap. No replace.	J.F. 09/01/26 mmw 09/01/06			
↓	↓	part moved while doing p.w.f.c. R.C. Process.						

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 2:33:17 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 45086

Part Number: D3121144

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

31 09/01/29

6.0

D312121

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3121-21

Bolt

B43536

09/01/30

7.0

D3121241

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3121-241 Bearing Ass

B43537

09/01/30

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3121-143 as per Dwg D3121.

09/01/30 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/30 (10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 233

9/2/07

(10)

SD

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/03

Job Completion



MF 09-02-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45086
Description: Bracket		Part Number: D3121-114
Inspection Dwg: D3121	Rev: E	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

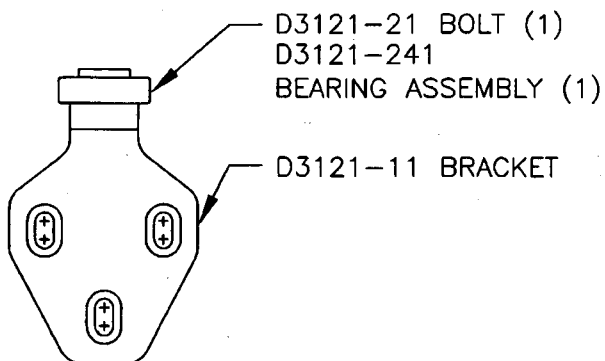
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.079"	✓			
0.300	+/-0.010	.298"	✓			
R0.375	+/-0.010	R.375"	✓			
1.54	+/-0.030	1.543"	✓			
0.350	+/-0.010	.350"	✓			
R0.25	+/-0.030	R.250"	✓			
Ø0.392	+0.002/-0.000	Ø.393"	✓			
Ø0.201	+0.005/-0.000	Ø.201"	✓			
0.100	+/-0.010	.095"	✓			
2.540	+/-0.010	2.535"	✓			
1.590	+/-0.010	1.587"	✓			
0.160	+/-0.010	.157"	✓			
0.400	+/-0.010	.401"	✓			
1.220	+/-0.010	1.223"	✓			
1.600	+/-0.010	1.603"	✓			
3.80	+/-0.030	3.794"	✓			
1.800	+/-0.010	1.803"	✓			
R0.50	+/-0.030	R.500"	✓			
0.130	+/-0.010	.127"	✓			
3.41	+/-0.030	3.387"	✓			
3.65	+/-0.030	3.637"	✓			
2.24	+/-0.030	2.210"	✓			
45°	+/-0.1°	45°	✓			
R0.25	+/-0.030	R.250"	✓			
3.97	+/-0.030	3.969"	✓			
R0.38	+/-0.030	R.380"	✓			
Ø0.392	+0.002/-0.000	Ø.393"	✓			
Ø0.201	+0.005/-0.000	Ø.201"	✓			
0.268	+/-0.010	.268"	✓			
R0.260	+/-0.010	R.260"	✓			
0.080	+/-0.010	.082"	✓			
0.300	+/-0.010	.303"	✓			
0.381	+/-0.010	.391"	✓			
0.201	+/-0.010	.207"	✓			

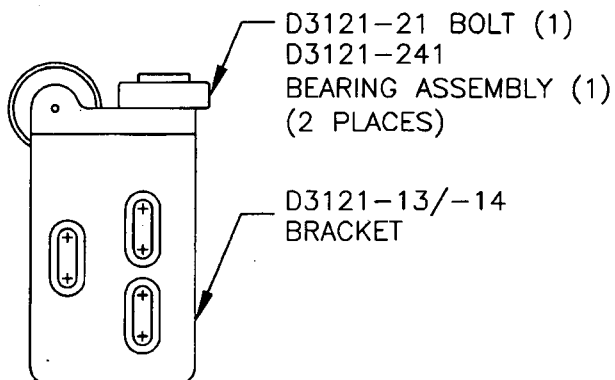


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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

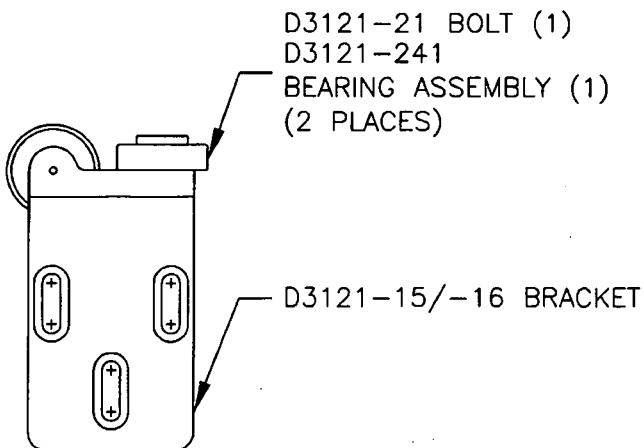
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07.11.07



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

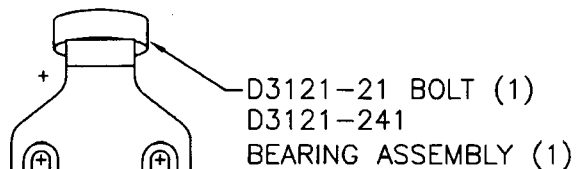
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

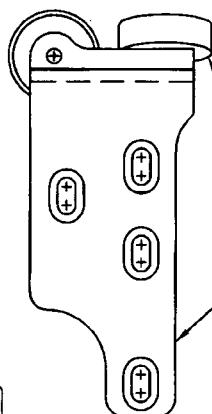


D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

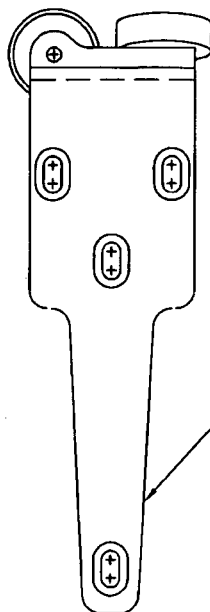
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07.11.07



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-05/-06)

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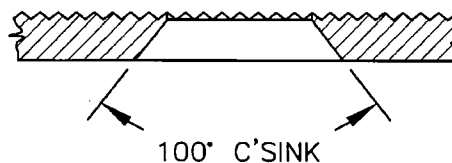
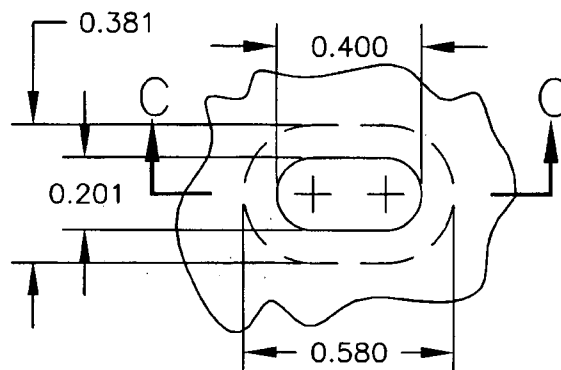
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

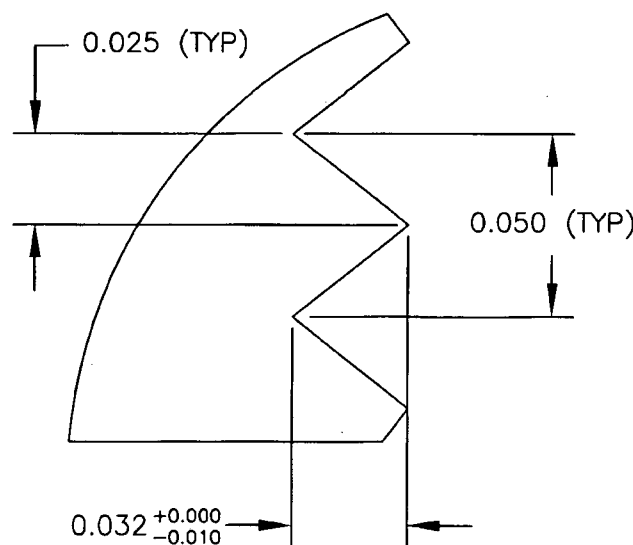
**DETAIL A:
SLOT DETAIL**
SCALE 2:1
VIEW ROTATED



**SECTION
C-C**

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07.11.07

**DETAIL B:
RIDGE DETAIL**
PARTIAL SECTION
SCALE 1:20



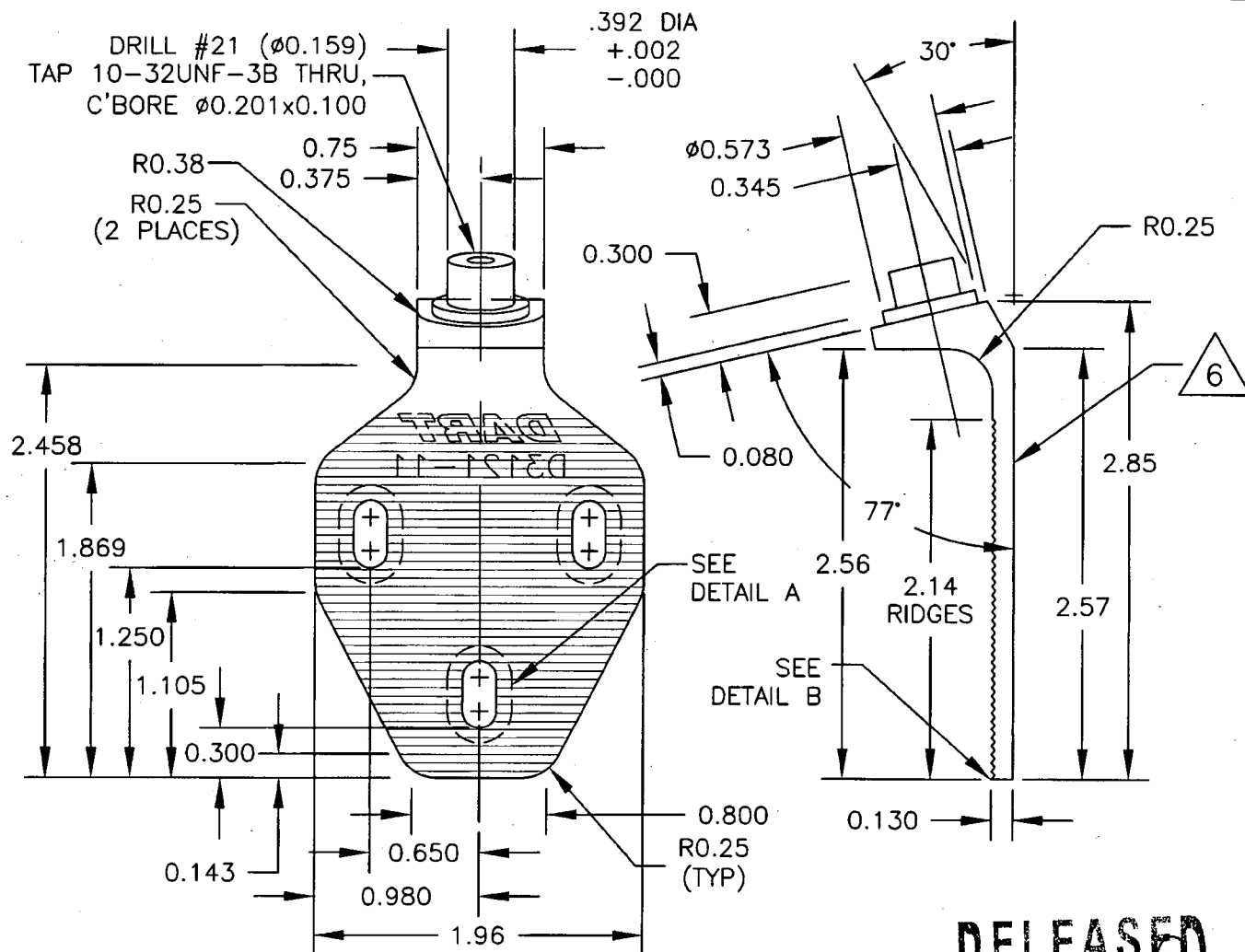
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**RELEASED**
07.11.07**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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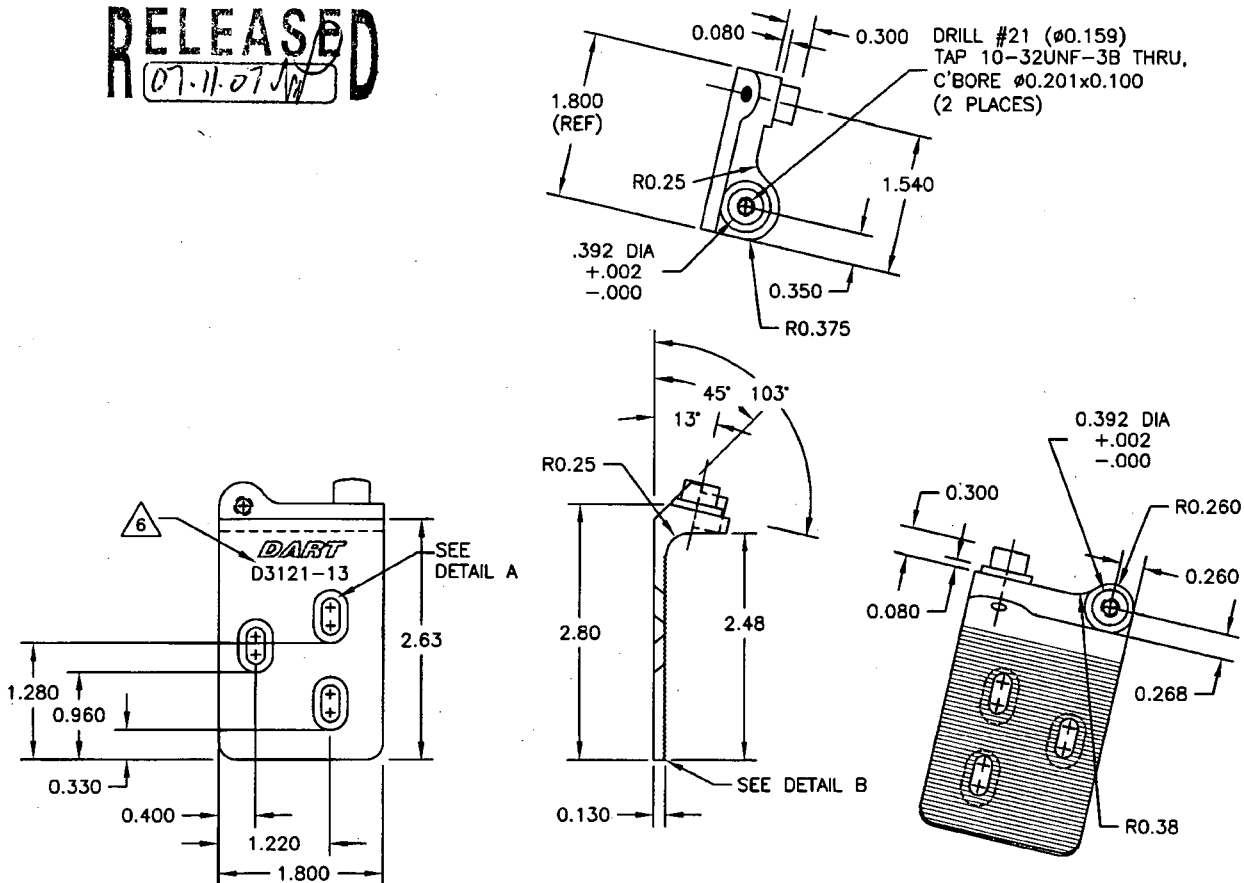
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07



D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

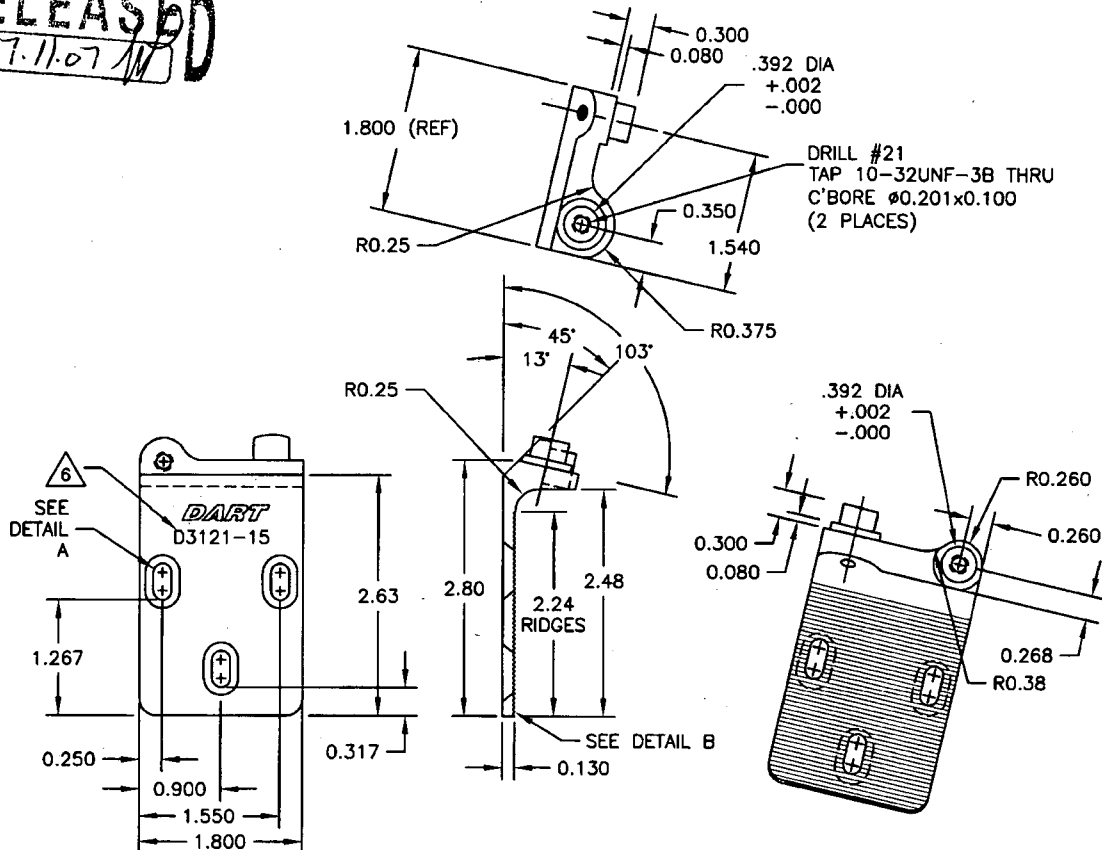
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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

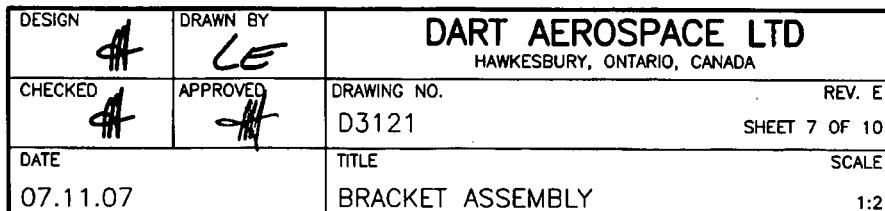
RELEASED
07.11.07**D3121-15 BRACKET (SHOWN)****D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

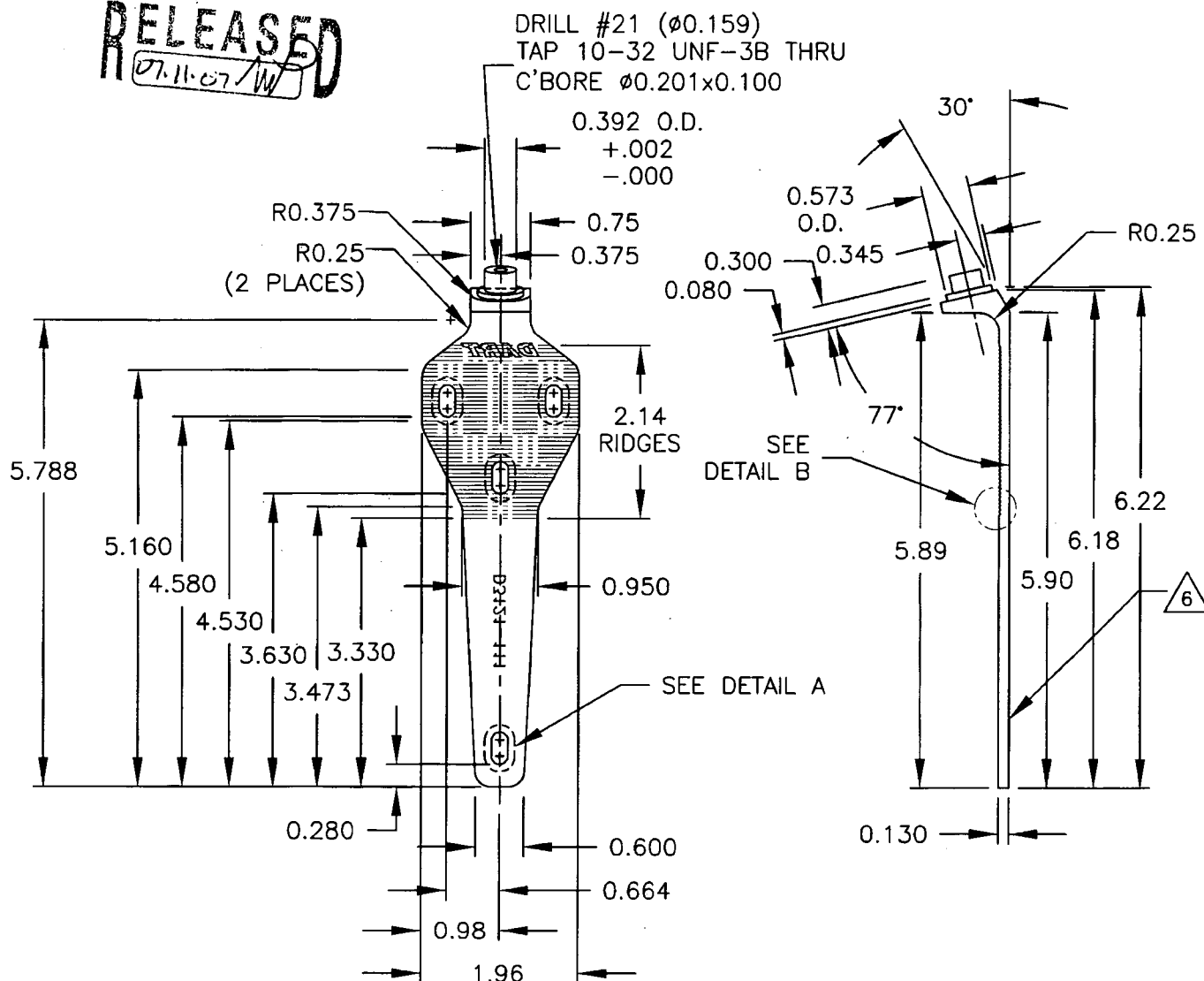
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RELEASED
07.11.07/W



- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

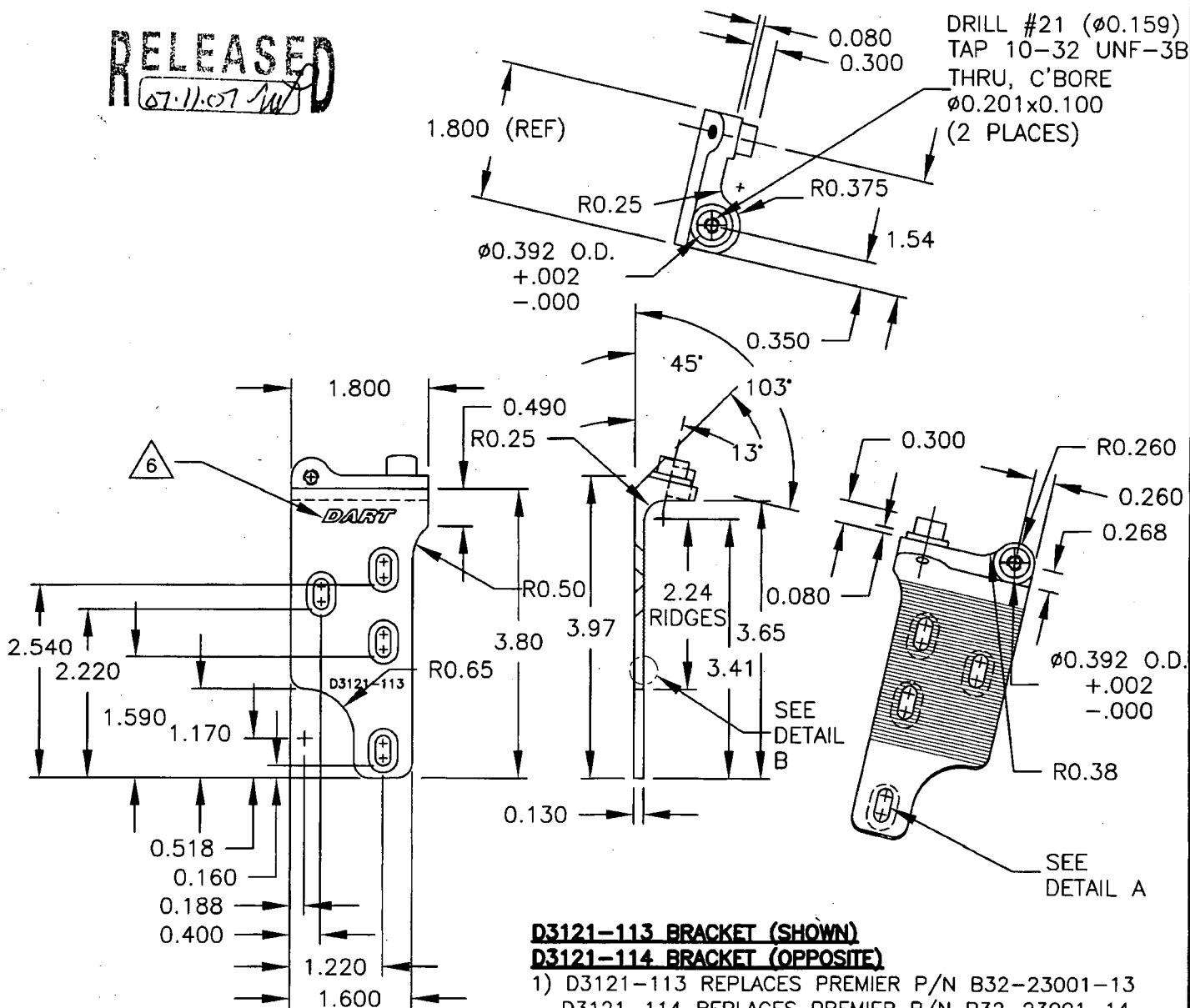
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07 W

D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643

(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi

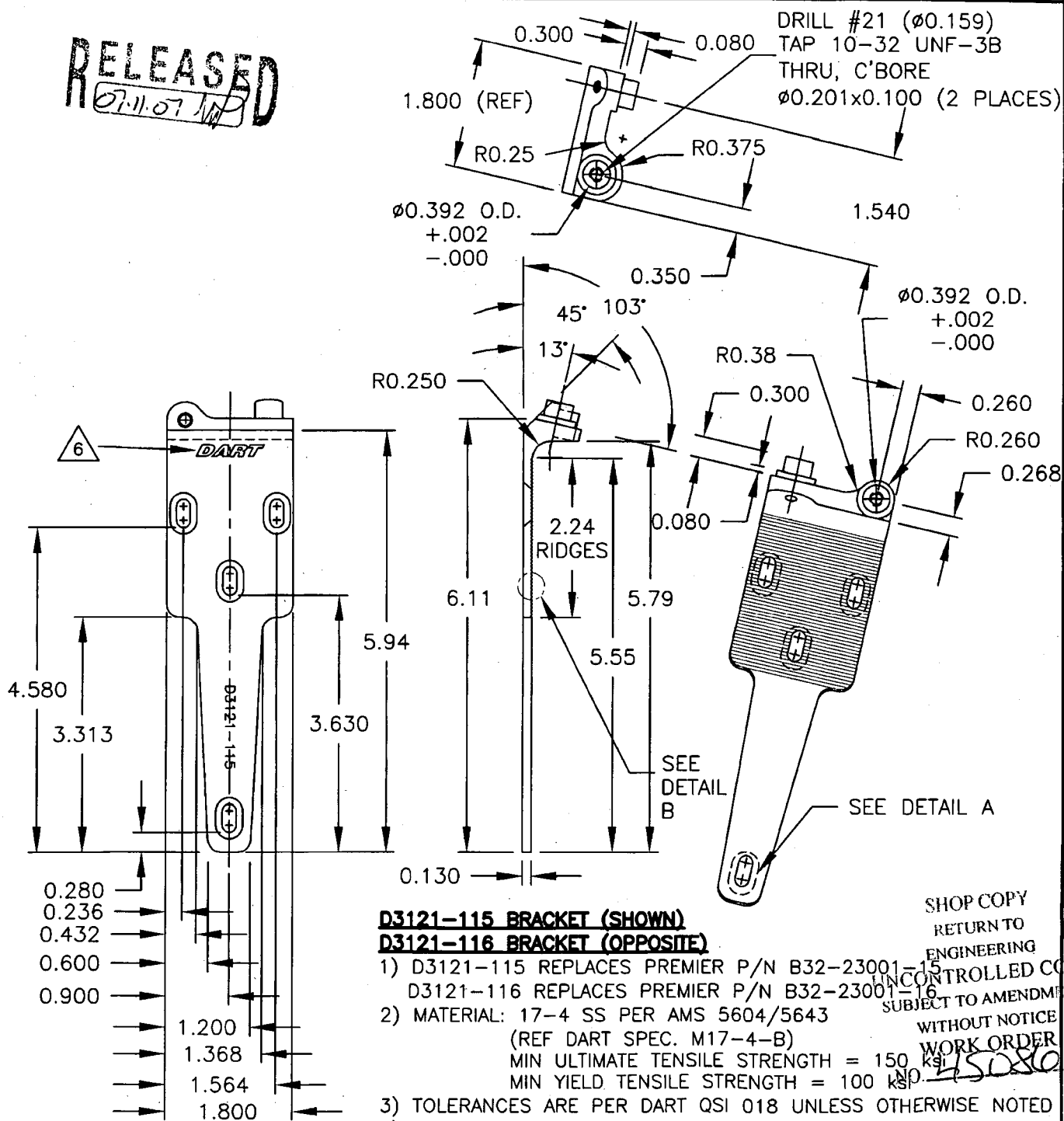
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015 WITHOUT NOTICE
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 9 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
07.11.07

D3121-115 BRACKET (SHOWN)
D3121-116 BRACKET (OPPOSITE)

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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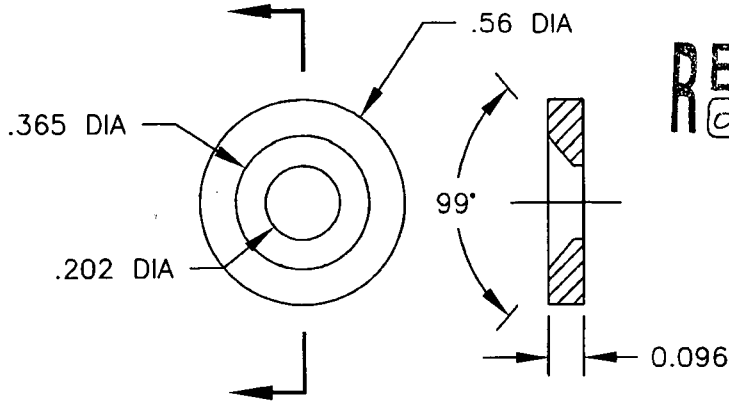
NO. 45080

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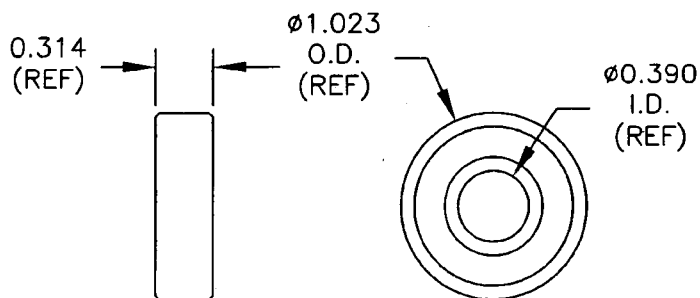
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DART

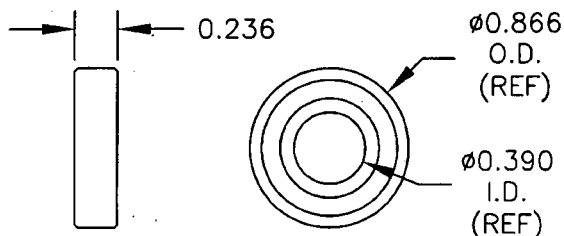
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

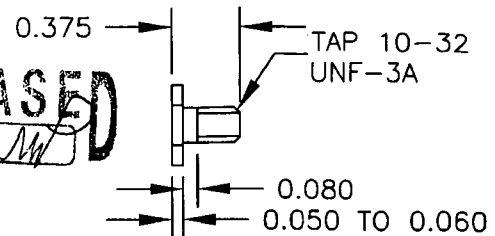
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

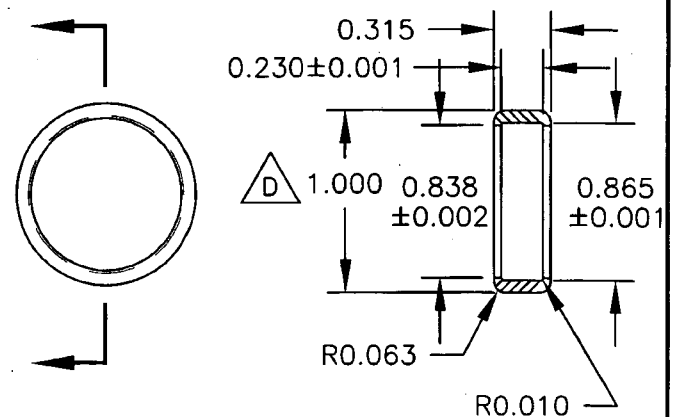
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

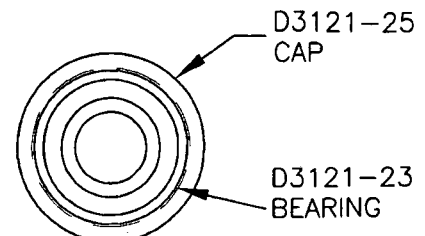
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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